

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000201**Date Inspected:** 06-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Mary Madere is present at the Ironworkers Apprenticeship Training Facility as requested by ABF for the continuing purpose of witnessing Procedure Qualification Record tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Company's Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson and Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector witnessed the completion of the first attempt of a Procedure Qualification Record (PQR) Test identified as ABF-PQR-022-1. This PQR test is being attempted using the flux-cored arc welding (FCAW-G) process with gas shielding and a mechanical device that travels on a magnetic track. Welder Mr. Dan Gordon deposited ten weld passes on this date. For specific welding parameters recorded during this PQR and digital photographs that support these observations, see Caltrans Welding Witness Report, TL-6032 generated on this date.

Summary of Conversations:

Quality Control Representative Mr. Michael Johnson informed the QA Inspector that the radiography which was previously scheduled for Friday, June 8, 2007 has been rescheduled for Monday, June 11, 2007. In addition, Mr. Johnson stated that Davis Laboratories would no longer be performing radiographic testing (RT) on this project and the PQR plates will be shipped to a different facility for RT.

On this date, the QA Inspector had a conversation with Caltrans Area Lead Inspector Mr. James Cochran regarding the PQR test plate identified as ABF-PQR-016-1B, which was previously welded using a separate zone

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in the root pass only. Mr. Cochran informed the QA Inspector that ABF has received verbal approval for zoning PQR test plates as needed as long as the QA Representative on site is notified. In addition, Mr. Cochran instructed the QA Inspector to issue a green tag for the identified PQR test plate. As previously documented, the welding of the identified PQR test plate was monitored by Caltrans QA Mr. Gregory Bertlesman. At the time of welding, Mr. Bertlesman did not green tag the test plate due to a twenty percent variation in travel speed. On this date, the QA Inspector issued a green tag containing lot number B67-026-07 to the identified PQR test plate.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Madere,Mary	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
